

Work Order ID 47883

July 1, 2009 1:41:19 PM

Page 1

Item ID: D412-742-043

Accept

Revision ID: H

Item Name: Replacement Float Skidtube

Setup Start

Stop

Start Date: 07/15/2009 Start Qty: 1.00

Required Date: 08/03/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per
PPP D412-742-043 CHG004

N/A

used in w/o 50153

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg
D3391 A/RLPS-3 N/A 2-Install tubes together and seal them all
the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle
holes for proper alignment. using 7/16" T

EXP: 10/01

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

⇒ 802/07/08

BR Lmd 09/07/08 (P10)

Picklist Print

July 1, 2009 1:41:18 PM

Work Order ID: 47883

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN3C4A *  ✓ BOLT		Purchased	No				Each	324.0000	24.0000 ✓			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 324

112082 *ump* 09/07/08 324

Each 976.0000 12.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 976

111982 *ump* 09/07/08 976

Each 329.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 329

105906 *ump* 09/07/08 21
107376 308

21
308

Op Seq	Work Center	Work Center Name	Standard Process	Process Descrip	Memo	Overlap %	Yield %	Last Modified By	Last Modified Date	Approved By
100	Large Fab	Large Fab			A	0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
110	QC	Quality Control	QC9	QC9- Inspect...		0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
120	QC	Quality Control	QC5	QC5- Inspect...		0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
121	HandFinish	HandFinishing	HandFinish2	Pressure Was...	a	0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
130	Powdercoat	Powder Coating	Powdercoat1	White Gloss(R...	A	0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
140	QC	Quality Control	QC3	QC3- Inspect...		0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
150	Packaging	Packaging	Packaging3	Identify as pe...		0.01 %	100 %	DUVA02	07/28/09 8:20 AM	
160	QC	Quality Control	QC21	QC21- Final I...		0.01 %	100 %	DUVA02	07/28/09 8:20 AM	

Date: Monday, 11/05/2009 1:40:14 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 47883		
Estimate Number	: 10756		
P.O. Number	:	Part Number	: D412742043
This Issue	: 11/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3391 REV.H
First Issue	: / /	Project Number	: N/A
Previous Run	: 46808A	Drawing Revision	: H
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 03/06/2009
Checked & Approved By	: <u>JLD 09.05.11</u>	Qty:	1 Um: Each
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM Est Rev:E 08-09-08 ecn 08-510 DD verified by:EC Est Rev:F 09-02-24 add D3591-1 DD Est Rev:G 09-03-30 remove D3591-1 DD verifeid by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG004 ✓

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 _____

N/A

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M111557Expiry date: 10/01

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251A/R Sikaflex-241/-291 M111557Expiry date: 10/01

4-Remove "T" pins once sikaflex is dry.

br. / mmd 09/07/08

W/O: 47883

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0907-17	110	Add a section to record the Sika Flex Batch #, incl expiration date. perm change	Change already completed	0907-30		0907-17	0907-17

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:40:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 47883

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

3.0

✓

D3391021

Fwd Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Fwd Tube Assembly

batch: 47300

used on # 7064

D3391-023

umc 09/07/08

4.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

47064

umc 09/07/08

5.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

48124

umc 09/07/08

6.0

D35641

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B48163

umc 09/07/08

7.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B48557

umc 09/07/08

8.0

D35643

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B46652

umc 09/07/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:40:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 47883

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE

B461104

UMP 09/07/08

10.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B48167

UMP 09/07/08

11.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)
BOLT
Batch: M112082

UMP 09/07/08

12.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)
BOLT
Batch: M110372

UMP 09/07/08

13.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
BOLT
Batch: M107376

UMP 09/07/08

14.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)
washer
Batch: M112116

UMP 09/07/08

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/07/08 G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:40:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 47883

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1

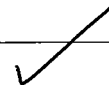


Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____



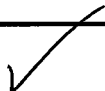
17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



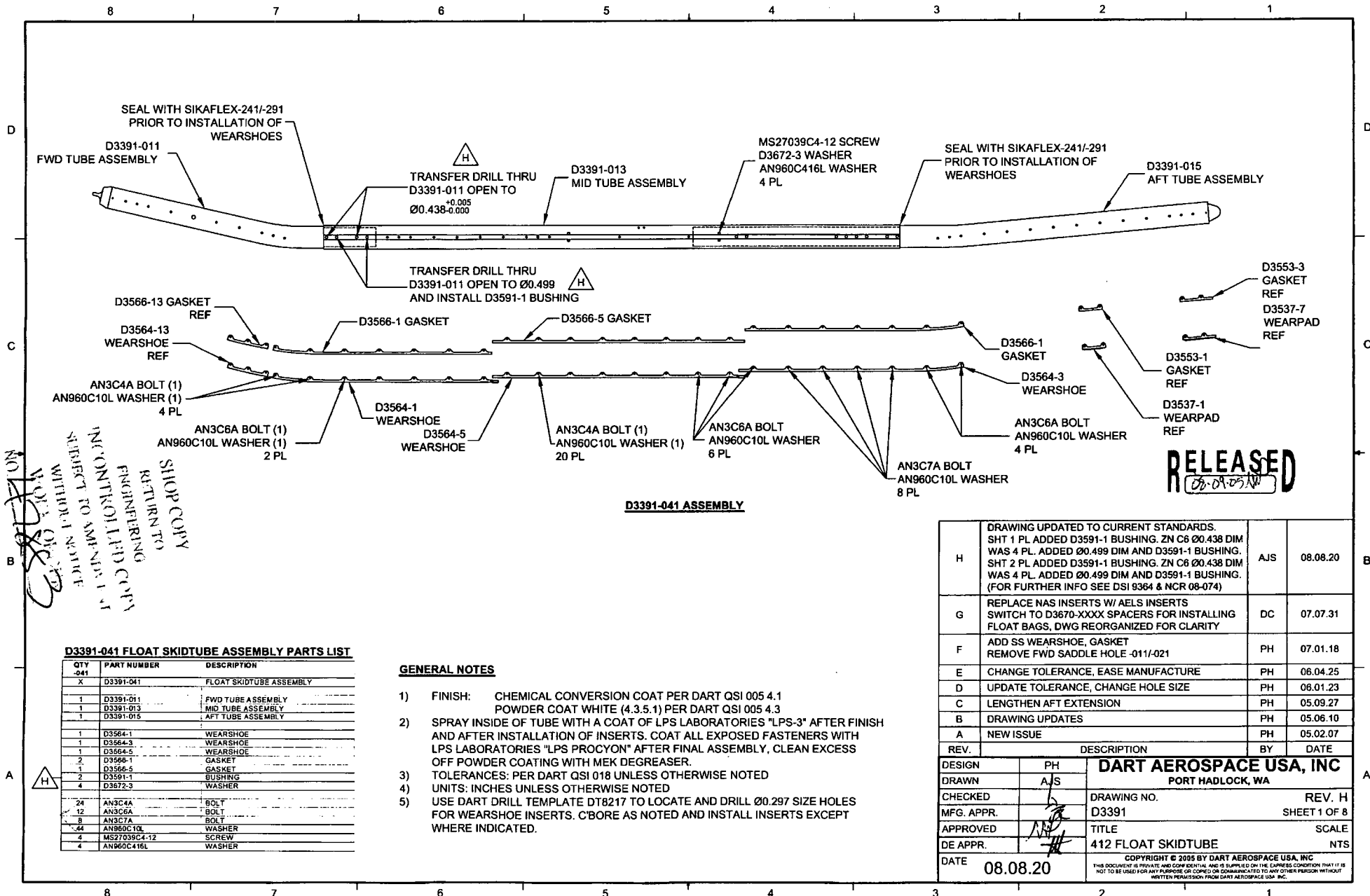
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

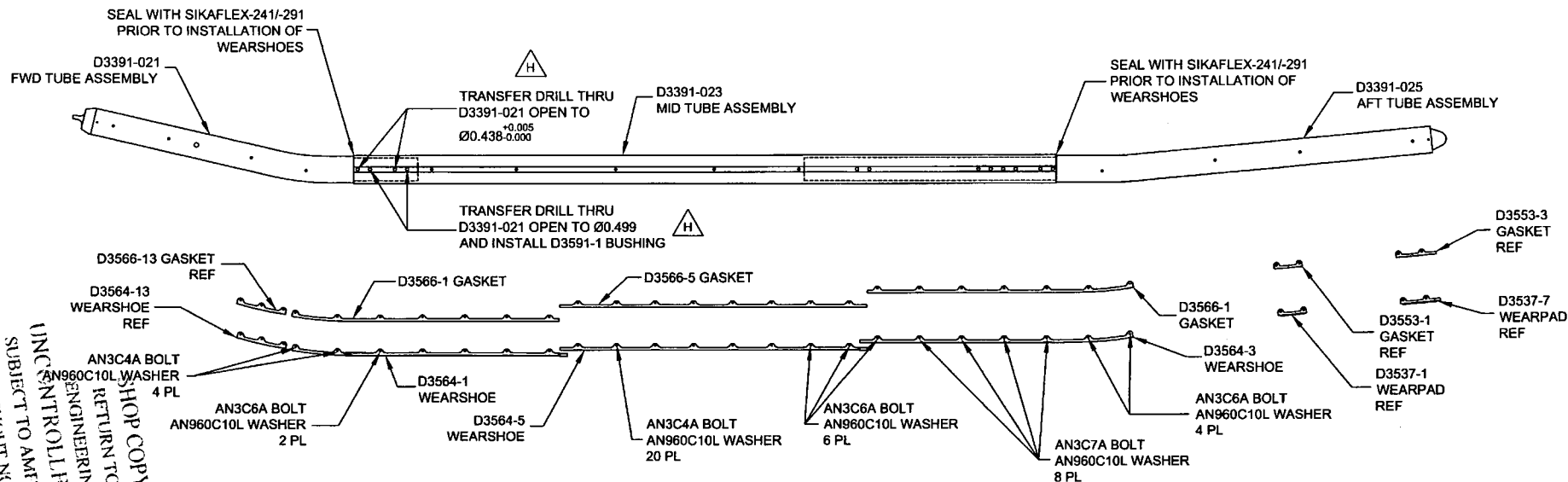
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

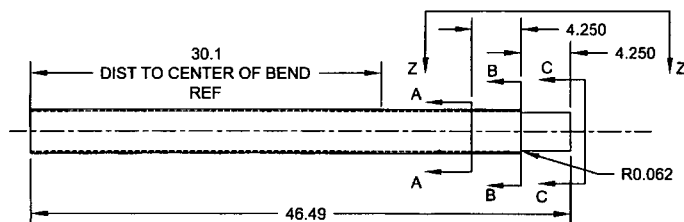
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

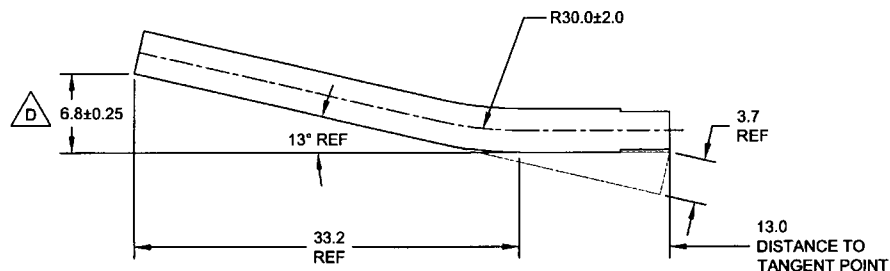
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

RELEASED
08-09-2008

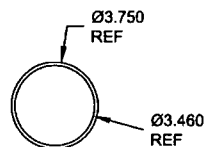
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
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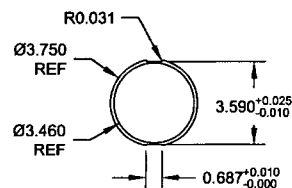
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



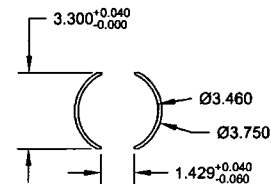
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



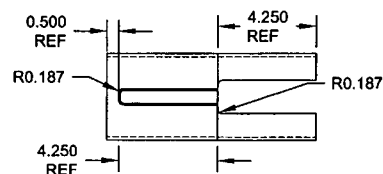
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X






SECTION C-C
SCALE 2X

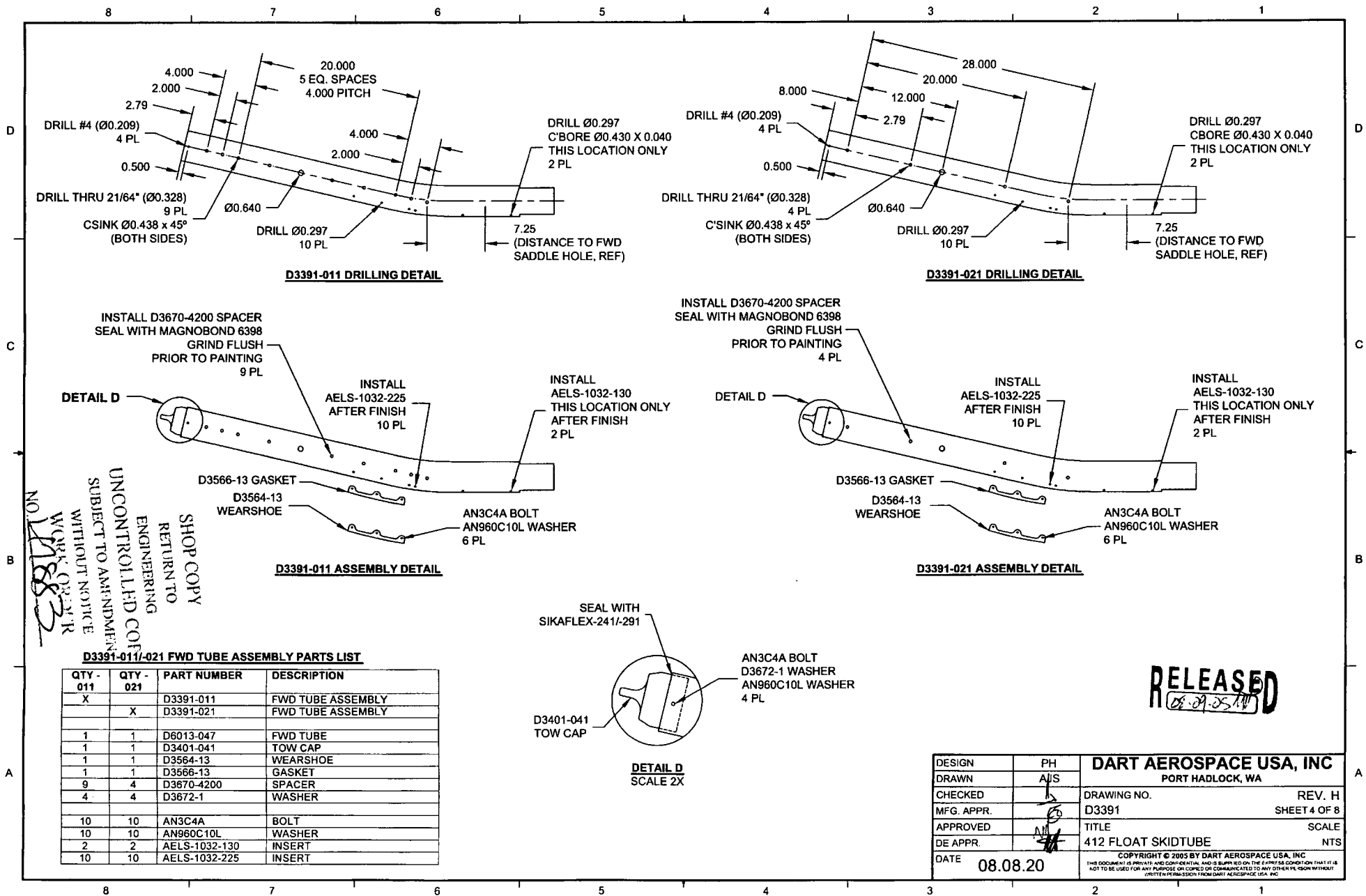


VIEW Z-Z
SCALE 2X

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42883

RELEASED
08-05-11

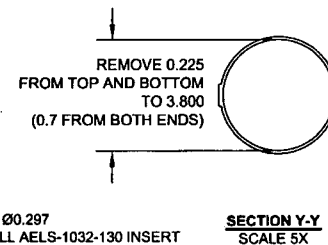
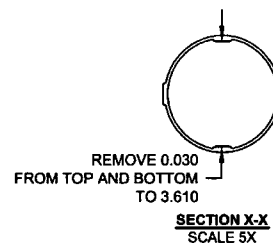
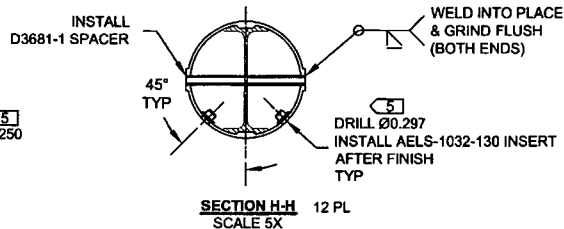
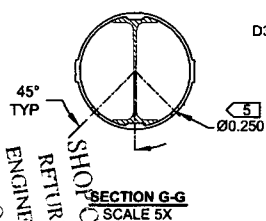
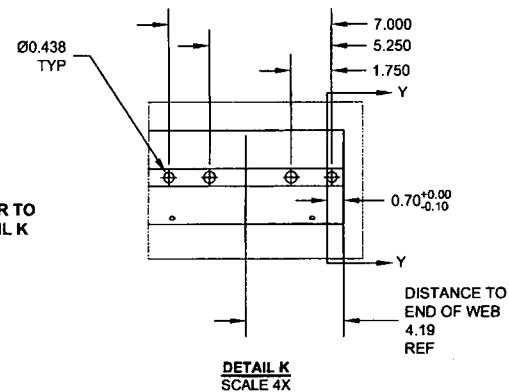
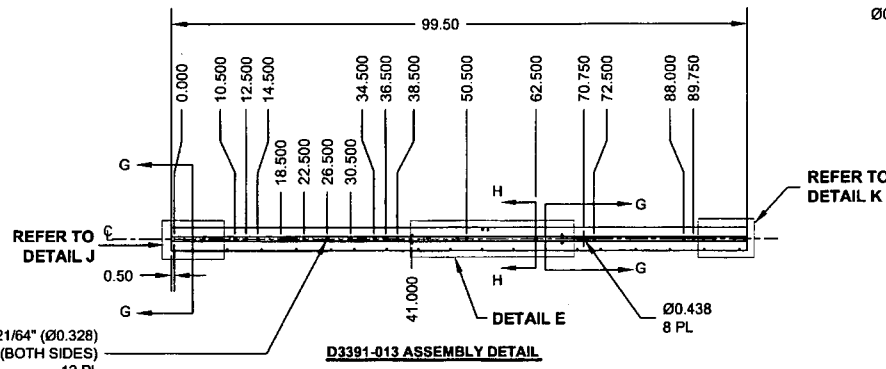
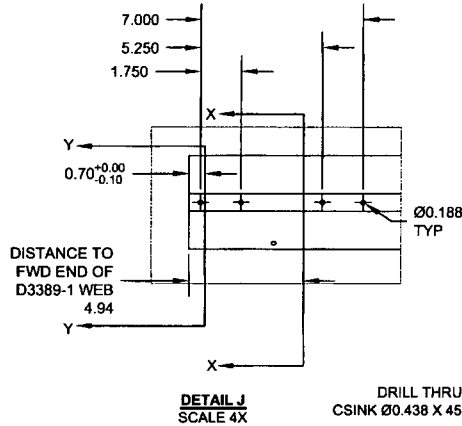
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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NO. 1183
WORK ORDER
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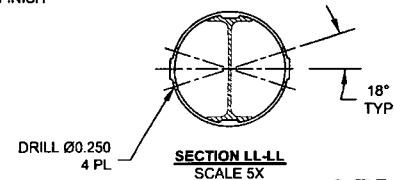
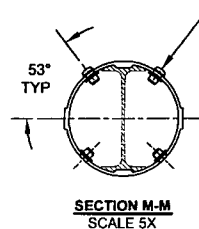
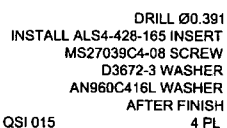
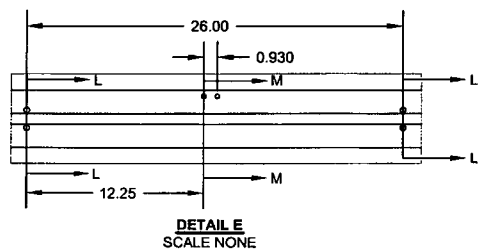
RELEASED
08-08-20

DESIGN		PH	DART AEROSPACE USA, INC	
DRAWN		AJS	PORT HADLOCK, WA	
CHECKED			DRAWING NO.	REV. H
MFG. APPR.			D3391	SHEET 4 OF 8
APPROVED			TITLE	SCALE
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

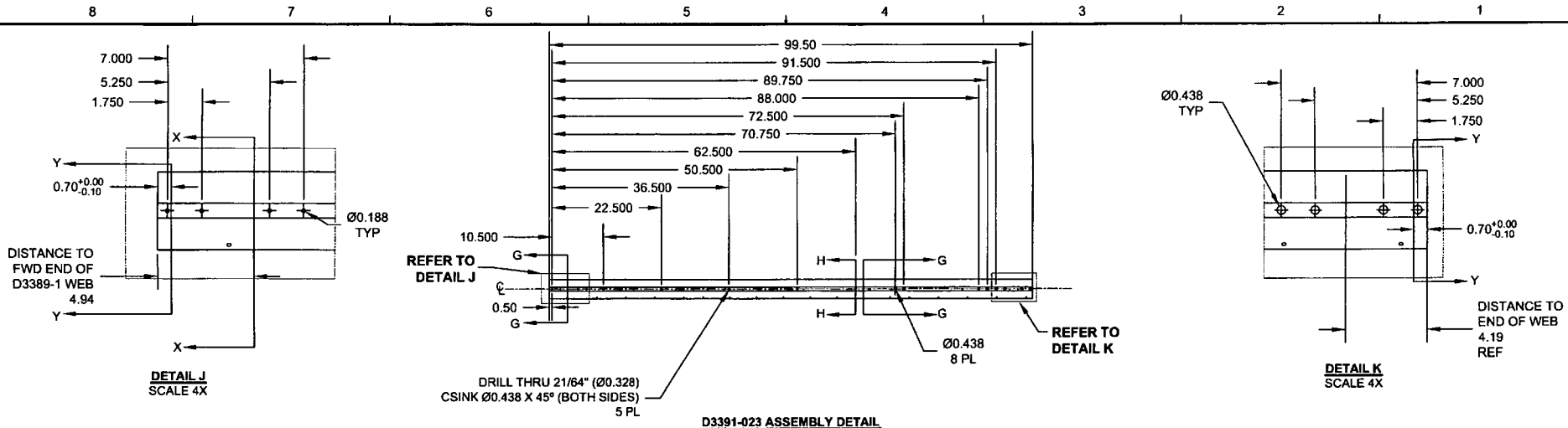


D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
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DETAIL J
SCALE 4X

DETAIL K
SCALE 4X

D3391-023 ASSEMBLY DETAIL

SECTION G-G
SCALE 5X

SECTION H-H
SCALE 5X

SECTION X-X
SCALE 5X

SECTION Y-Y
SCALE 5X


D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

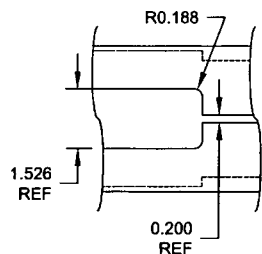
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

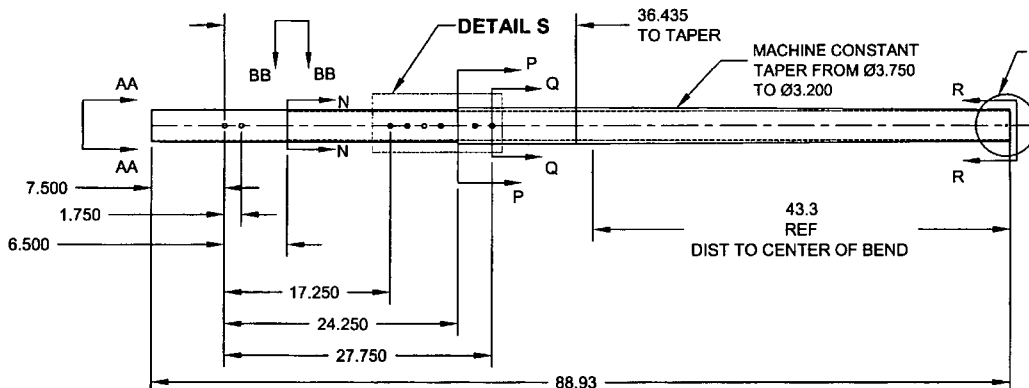
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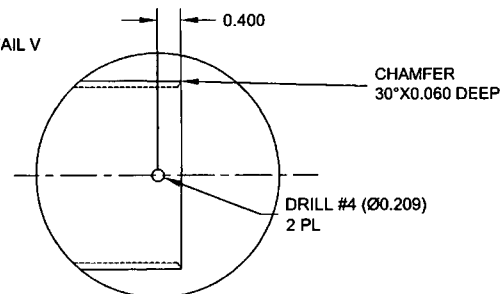
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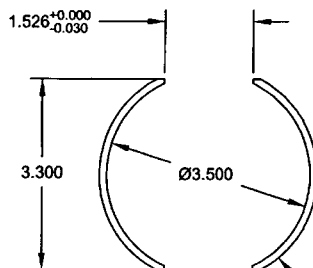
VIEW BB-BB
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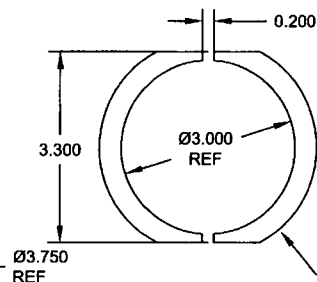
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



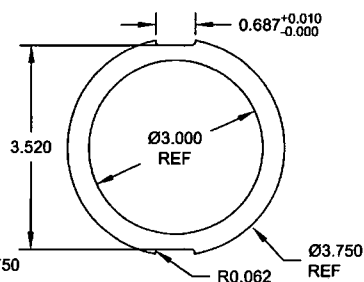
DETAIL V
SCALE 6X



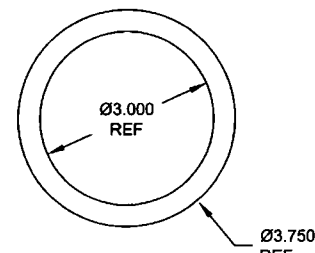
SECTION AA-AA
SCALE 6X



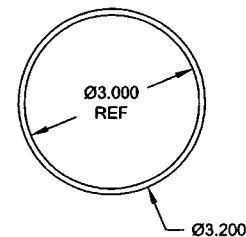
SECTION N-N
SCALE 6X



SECTION P-P
SCALE 6X

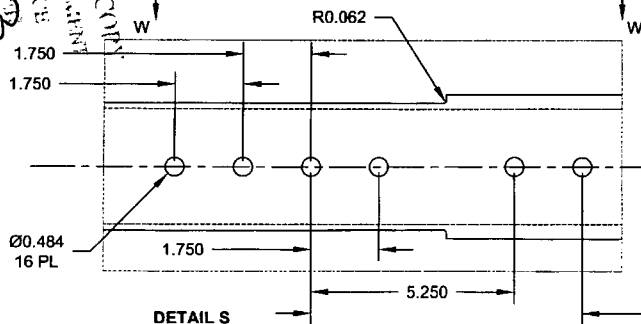


SECTION Q-Q
SCALE 6X

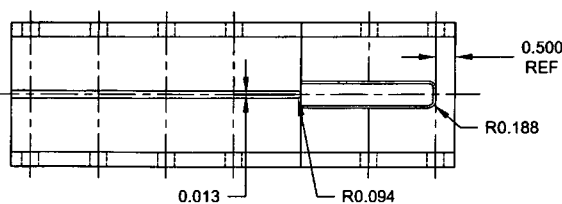


SECTION R-R
SCALE 6X

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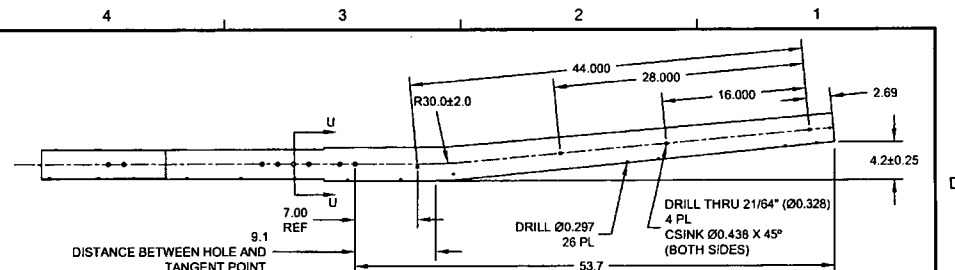
DETAIL S
SCALE 4X



VIEW W-W
SCALE 4X

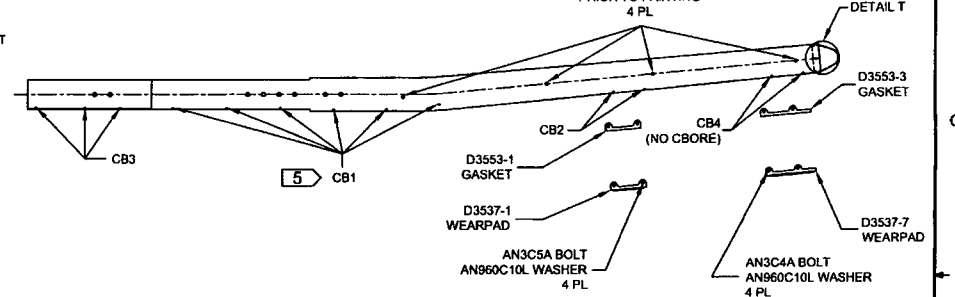
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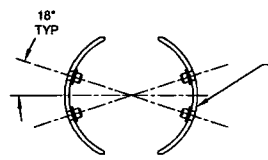
D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL



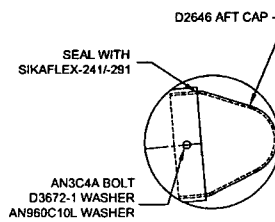
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

QTY - 015	QTY - 026	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AEIS-1032-130	INSERT
12	12	AEIS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DETAIL T
SCALE 4X

RELEASE
08-09-05 11/1

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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